

Work Order ID 72209

Wednesday, July 20, 2011 7:52:48 AM



Page 1

Item ID: D2803-042

Accept



Setup Start



Revision ID:

Item Name: Bracket Assembly

Stop



Start Date: 7/19/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/26/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-07-20 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2803

Rev B

100



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Press D2805-2 and D2809 into arm as per Dwg D2803

9/5/08/09 (5)

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

5 11/08/10

(7)

047

120



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:30 AM OVEN TEMPERATURE:

FINISH TIME: 11:00 PM

320°

5 of 11/08/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

0.00

5x 1/11/08/10

150

Small Fab

0.00



Small Fab

Memo

Small Fab

Assemble as per Dwg D2803.

0.00

11/08/11 (5)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

Quality Control

0.00

Suloski

(45)

242

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: 149

0.00



Packaging

Memo

0.00

Packaging

11/8/15 (S) SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/15 JG

ME
11-08-15

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, July 20, 2011 7:52:54 AM

Page 1

Work Order ID: 72209

Parent Item: D2803-042

Parent Item Name: Bracket Assembly



Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2803-2 		Manufactured	No			100	Each	0.0000	1	4			
Bracket													
D2805-2 		Manufactured	No			100	Each	0.0000	1	4			
Stop													
* NAS1515H3 		Purchased	No			100	Each	146.0000	4	16			
Washer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST277		146							
				116373		6							
				117460		58							
				118078		82							
AN3C16A 		Purchased	No			150	Each	45.0000	2	8			
Bolt													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST352		45							
				115835		5							
				118191		40							

B 71569 (5x)

B 71559 (5x)

M118.384
(8x)

7/11/08/09
7/11/08/09
7/11/08/11
7/11/08/11
10

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 2

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Parent Item: D2803-042

Parent Item Name: Bracket Assembly

Start Date: 7/19/2011

Required Date: 7/26/2011

Start Qty: 4.00

Required Qty: 4.00

D2809

Manufactured No

150

Each

18.0000

1

4



Bushing



Handwritten: 7/21/08/11
B72735 (52)

Location

Loc Qty

Loc Code

ST

6

70805

6

ST023

12

34035

12

MS21043-3

Purchased No

150

Each

776.0000

2

8



Nut



Handwritten: 7/21/08/11
10

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

704

112314

33

118077

671

Wednesday, July 20, 2011 7:52:55 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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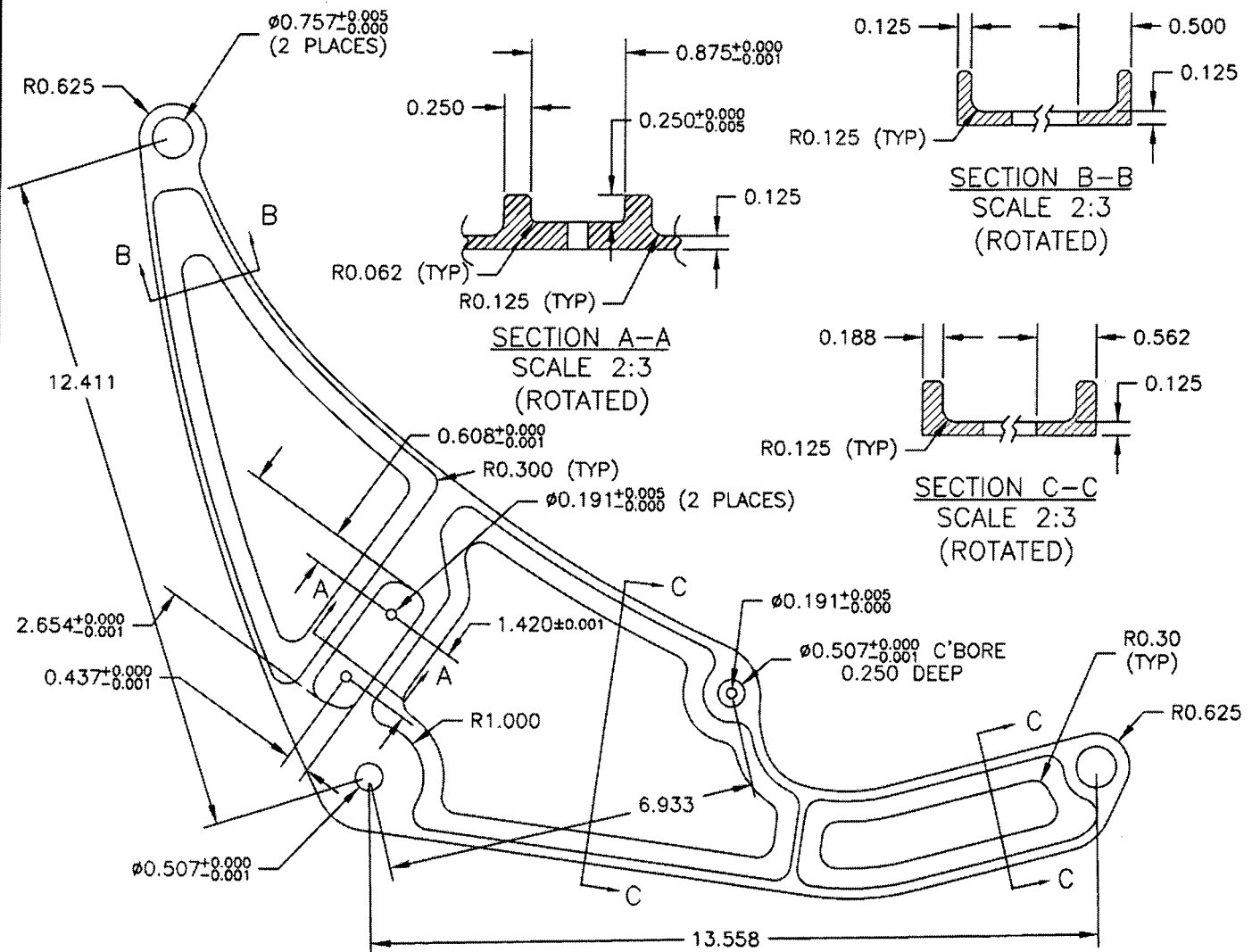
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
DART
SUBJECT TO AMENDMENT
NOTICE
WORK ORDER

NO. 72209

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
				HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2803
				REV. B SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE		
B	04.11.22	ADD CUTOUTS & -043/-044		

RELEASED

05.03.11 *[Signature]*



D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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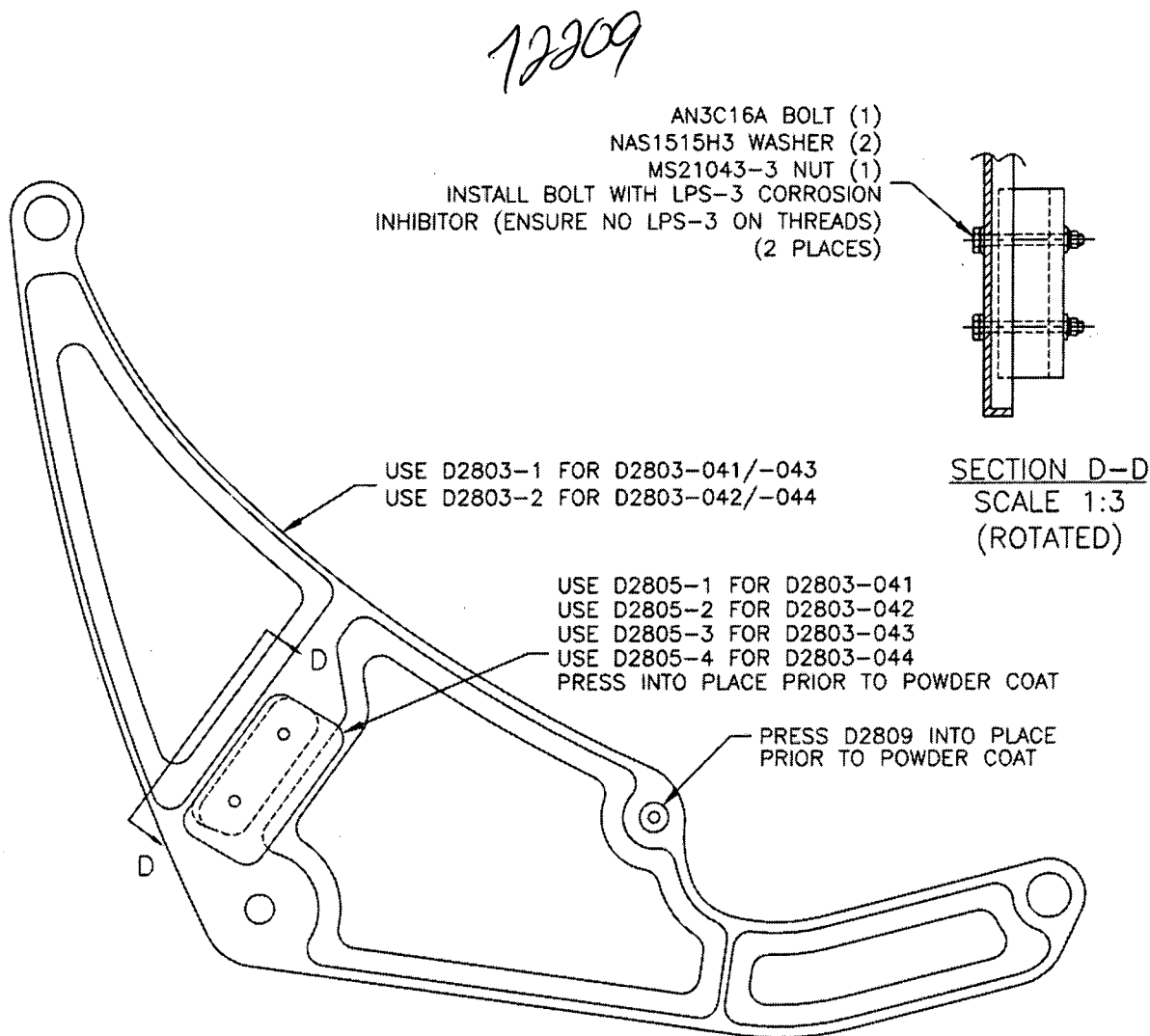
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



RELEASED

05-03-11

D2803-041/-043 BRACKET ASS'Y (SHOWN),
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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